



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4276-1

Job Sheet 180390



Part No: D4276-1

Job Qty: 3 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 7/12/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV:A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	7/12/18	7/12/18	0.00	0.00	Start Up Machining-2		DAS 18/07/13
100	Bandsaw	3 pcs	7/12/18	7/12/18	0.00	0.05	Bandsaw1		52 - 18/07/13
110	CNC Vertical Machining	3 pcs	7/12/18	7/12/18	0.58	5.36	HAAS1-4		9-89 18/07/13
120	QC	3 pcs	7/12/18	7/12/18	0.00	0.00	QC2 Machining-2		18/07/13
130	QC	3 pcs	7/12/18	7/12/18	0.00	0.00	QC8 Machining-2		18/07/13
140	HandFinish	3 pcs	7/12/18	7/12/18	0.00	0.35	HandFinish1		SA 18-07-23
145	Powdercoat	3 pcs	7/12/18	7/12/18	0.00	0.27	Powdercoat1		BL 18-7-23
150	QC	3 pcs	7/12/18	7/12/18	0.00	0.00	QC3		38
180	Packaging	3 pcs	7/12/18	7/12/18	0.00	0.00	Packaging3-2		JUL 27 2018
190	QC21-SA	3 Ea	7/12/18	7/12/18	0.00	0.00	QC21		JUL 30 2018

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

M/38834 START: 3:55 CUT: 3:00 FINISH: 4:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	9.1560 ft (3.052 ea)	90-Start up Operation	5090370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	9	9	0

Part Specifications

Specifications could not be found.

Plex 7/5/18 1:44 PM dart.lacelle.linda

M6061T6B1.000X04.000
S090370

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval			
Description Work Order Deviation		 DART AEROSPACE Container No: S091805 Part: D4276-1 Job No: 180390 Serial No/ Batch: S091805 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/13/18 DART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON K8A 1K7 CANADA TEL: 513 632-5200 Email: sales@dartaero.com www.dartaero.com					
						Completed By	
						Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval					

Root Cause			
Environment	☐	No Re	☐
Design	☐	Operat	☐
Doc/Data	☐	Offset/:	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Tes	☐
Internal Transport	☐	Poor Inform	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Imprc	☐
Substation	☐	Process Improv	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

s/Surge am Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	s/Surge am Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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Marks/Chatter Drill Holes	Cut Too Short Instructions Incomplete/Unclear	OTHER : _____
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DART AEROSPACE LTD		Work Order:	180390
Description: Aft Beam		Part Number:	D4276-1
Inspection Dwg: D4276	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.75	✓		Ver	
20.500	+/-0.010	20.500	✓		TAPE	
Ø0.381	+0.000/-0.001	Ø.380	✓		G.P.	
14.380	+/-0.010	14.380	✓		TAPE	
R0.75	+/-0.030	R0.75	✓		R.G.	
3.50	+/-0.030	3.500	✓		Ver	
16.38	+/-0.030	16.38	✓		TAPE	
5.00	+/-0.030	5.00	✓		Ver	
0.75	+/-0.030	0.75	✓		Ver	
2.75	+/-0.030	2.75	✓		Ver	
3.00	+/-0.030	3.00	✓		Ver	
1.250	+/-0.010	1.250	✓		Ver	
4.50	+/-0.030	4.50	✓		Ver	
0.734	+/-0.010	0.734	✓		Mic	
0.108	+/-0.010	0.108	✓		D.G.	
36.38	+/-0.030	36.38	✓		TAPE	
0.95	+/-0.030	0.950	✓		Ver	
0.60	+/-0.030	0.60	✓		Ver	
2.70	+/-0.030	2.70	✓		Ver	
1.10	+/-0.030	1.10	✓		Ver	
1.25	+/-0.030	1.25	✓		Ver	
0.75	+/-0.030	0.75	✓		Ver	
3.000	+/-0.010	3.000	✓		Ver	
1.500	+/-0.010	1.500	✓		Ver	
Ø0.191	+0.005/-0.001	Ø.193	✓		Ver	
2.300	+/-0.010	2.300	✓		Ver	
3.50	+/-0.030	3.50	✓		Ver	
R0.60	+/-0.030	R.60	✓		R.G.	
1.70	+/-0.030	1.70	✓		Ver	
0.65	+/-0.030	0.65	✓		Ver	

Measured by:	989	Audited by:	[Signature]	Preliminary Approval:	
Date:	18/07/13	Date:	18/07/13	Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ [Signature]	[Signature]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER: ☐					